

# INFRALIT EP/PE 8086-05

## zinc epoxy polyester powder

<b>PAINT TYPE</b>	INFRALIT EP/PE 8086-05 is a powder coating based on epoxy and polyester resin containing metallic zinc, which has very good anticorrosive properties. At elevated temperature the powder melts, cures and forms the final paint film.
<b>USAGE</b>	INFRALIT EP/PE 8086-05 is mainly suitable for use on steel surfaces blast-cleaned to preparation grade Sa 2½, when the constructions will be exposed to severely corrosive environments. The product is designed mainly for use as a primer.
<b>SPECIAL PROPERTIES</b>	<p>INFRALIT EP/PE 8086-05 forms a mechanically resistant paint film that has good anticorrosive properties. The surface can be overcoated with INFRALIT Powder Coating or some other suitable paint.</p> <p>Teknos sales department should be contacted if the intention is only to melt the primer before applying the top coat.</p> <p>Overbaking of INFRALIT EP/PE 8086-05 powder coating must be avoided when overcoating. If the stoving temperature of the primer is higher than 205°C, the adhesion between the coats may be diminished. We recommend that intercoat adhesion is always checked when direct fired gas oven is used in two layer painting.</p>

**TECHNICAL DATA**

<b>Spraying</b>	The product is suitable only for corona charging spray.
<b>Colours</b>	Dark grey
<b>Gloss grades</b>	Semigloss
<b>Solids</b>	100%
<b>Specific gravity</b>	2,6 kg/dm <sup>3</sup>
<b>Spreading rate</b>	abt. 6 m <sup>2</sup> /kg depending on the film thickness
<b>Film thickness</b>	abt. 60 µm above the peaks of the surface profile
<b>Curing time</b>	10 min/180°C (metal temperature).
<b>Storage</b>	In dry and cool conditions.

**SAFETY PRECAUTIONS**

The powder itself is non-flammable, but with air it can form an explosive mixture that in presence of adequate ignition energy ignites. Ventilation of the spray booth should be adjusted so that the highest concentration of powder in the air is 10 g/m<sup>3</sup>. On calculation of the powder concentration in the spray booth, the powder deposited on the workpiece is not taken into account.

In order to avoid the discharge of powder from the booth into adjacent working spaces, the speed of air flow in the apertures of the booth must not fall below 0.5 m/s.

Spray painters should wear dust masks and protective gloves. Any spatter of powder on the skin should be washed off with water and soap.

Welding is to be avoided due to the zinc content of the powder.

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**DIRECTION FOR USE****Surface preparation**

STEEL SURFACES: Remove grease and dirt. Thereafter the surfaces are blast-cleaned at least to preparation grade Sa 2½ (ISO 8501-1). The surface profile has to be at least medium coarse (G) SFS - ISO 8503-2. Remove the dust.

INFRALIT EP/PE 8086-05 can be used with other paints or alone if the grey colour can be accepted. When used alone, the recommended minimum film thickness is 80 µm.

**FILM PROPERTIES**

Substrate cold-rolled steel, curing time 10 min/180°C:

**Typical values**

Flexibility (Erichsen, ISO 1520)	7 mm
Impact resistance (Erichsen, SFS EN ISO 6272)	
- direct	40 kgcm
- reverse	40 kgcm
Flexibility (SFS ISO 6860)	passes
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages [www.teknos.com](http://www.teknos.com).

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